'Date:	Monday, 1/14/2008 2:32:16	PM						
≯User:	Kim Johnston		Proce	ess Sheet	·			
Customer Job Number Estimate Num P.O. Number This Issue Prsht Rev. First Issue Previous Rum Written By Checked & A Comment Additional Pr	: 36726 nber : 11131 : : : 1/14/2008 : NC : / / : : : : : : : : : : : : : : : : :	Dart Helicopters Service  S.O. No. :  Type : MACHIN  A 02.05.30 New Iss	ED PARTS	Part Number Project Number Project Number Drawing Revision Material Due Date	: PIVOT  : D31141 : D3114 REV B : N/A : B : : 2/10/2008	Qty:	<i>20</i> & Um:	Each
Job Number:								
Seq. #:	Machine Or C	Operation:		Description :				
1.0	M303H0500		303 HEX	BAR			(20	9
С	•	612 f(s)/Unit Total :	0.2449 f(s)		Ŋ	.A 0	8/01/25	
	303 HEX BA		havbar (DADT ar	M202H0 E00 \	Dotoh	1106	789	
	Mati. Alsi 30	03 Stainless steel ½" l	riexbar. (DART Sp	Jec. 10303H0,300 )	Date	1		
2.0	HAAS1	v	HAAS CN	C VERTICAL MACHINING	G #1			`
							(20	")
С		VERTICAL MACHINII	NG #1					
		per Folio FA244 k all unmarked sharp e	edges 005 to 0.01	0	B.A	land	08/01/2	ς .
3.0	QC2	*		PARTS AS THEY COME		172		<u>., ,                                  </u>
21				·			<b>20</b>	<b>)</b>
		ARTS AS THEY COM			<u>,E), A</u>	PM	08/01/2	25
4.0	QC8		SECOND	CHECK				
C	omment: SECOND CI	HECK			J.F	<u>ده ۲</u>	2/01/27	X
5.0	PACKAGING 1		PACKAG	ING RESOURCE #1				
Co	omment: PACKAGINO							
	Identify with Location:	P/N and B/N using a p	permanent fine po	int marker, then Stock	1/28	ر ن ک	)	
				C.,. /	1			
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Dart Ae	rospace Li	td							
W/O:			WORK ORDER	CHANGES					
DATE	STEP	PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Category:	NCF	R: Yes (N	DQA	<i>1:</i> <u>D</u>	Date:	28/01/80
					QA: N/	C Closed	l:	_ Date: _	
NCR:		V	VORK ORDER NON-CON	IFORMANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Actio		Cian 9	Verific	ation	Approval	Approval

		WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B	Varification	Approval						
TEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date			Approval QC Inspector				
		:									
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		Section A	Section A	Section A minda Action Description	Section A minute Action Description	Section A Section C Section C	Section A Action Description Section C Chief Eng				

NOTE: Date & initial all entries

Date:

Monday, 1/14/2008 2:32:16 PM

Kim Johnston Üser:

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIVOT

Job Number: 36726

Part Number: D31141

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



= 2008/1/26



## **Dart Aerospace Ltd**

DuitAt	oopaoo								
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,					
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
					QA: I	N/C Close	d:	Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMA	ANCE (NCI	₹)			
		Description of NC		ion B	Verifi	rification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Section Section	on C	tion Approval Chief Eng	QC Inspector
								:	
								•	
								:	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 36 7.	26
Description: PIVOT	Part Number: D 3114	1
Inspection Dwg: D3114 Rev: B	Pag	e 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
ø.250	+.0000	8.249	/			
\$0.186	010 min = .184 max= .190	Ø. 188				
0.500(TYP)	+/010	.497				
0.084	+/010	0.084				
0.061	+/010	0.062	<b>✓</b>			
0.250 (REF)	+/010	, 249				
0.162	+/010	0.162	. /			
0.439	+/010	0.440	<b>/</b>			
0.500 (REF)	+/010	·502	<b>/</b>	<u> </u>		
0.030 x 45°	+1- 20/ +1010	,034×45°	<i>J</i>			
10-32 UNF3A	2 14	M = .2134				
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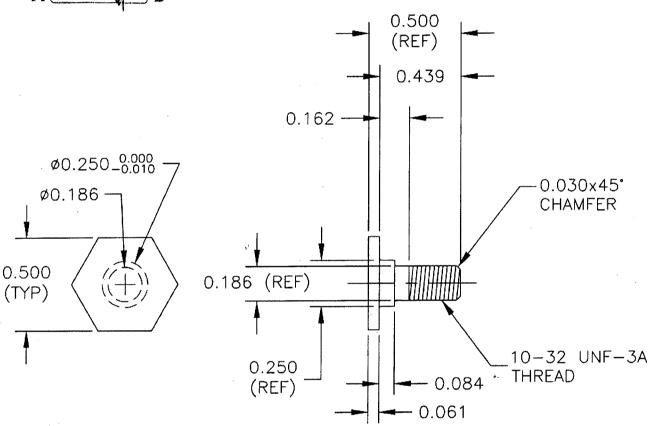
No. 1	,			
Measured by:	4A/9n	Audited by:	Prototype Approval:	
	08/01/25	Date: 08/0	1/25 Date:	
Date.	08/01/25		7-0	

	Data	Change	Re	evised by	Approved
Rev	Date	Change	KJ	/RF	
Α		New Issue		<del></del>	





DESIG	N AF	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	(ED //	APPROVED	DRAWING NO. REV. B
	#	#	D3114 SHEET 1 OF 1
DATE	<u> </u>	<u> </u>	TITLE SCALE
04.1	0.18		PIVOT 2:1
Α		02.04.12	NEW ISSUE
В		04.10.18	ADD PART MARKING; ADDED ANNEALED



D3114-1 PIVOT

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY

MATERIAL: ANNEALED AISI 303 STAINLESS STEEL 1/2" HEX BAR STHOLT NOTICE (REF DART SPEC. M.303H0 500) **NOTES:** 

FINISH: NONE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES 0.005 TO 0.015

IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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